

52

SPLIT

DART AEROSPACE LTD

Work Order:

21953A

Description: Support Assembly

Part Number:

D3278-041

Dwg: D3278 Rev. A

Qty:

100

Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler DWG NOT REQUIRED 04.07.05	Er	04.11.23	100
2	MV	Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Identify for D3278-1	Er	05/01/06	100
3	MV	Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Identify for D3278-2	Er	05/01/06	100
4	MV	Machine D3278-1 as per Folio FA405 and Dwg D3278 Identify as D3278-1	Er	05/01/12	100
5	QC2	Inspect parts as they come off the CNC machine	Er	05/01/12	100
6	MV	Deburr and Tumble	Er	05/01/12	100
7	QC8	Second check	Er	05/01/13	100
8	MV	Machine D3278-2 as per Folio FA405 and Dwg D3278 Identify as D3278-2	Er	05/01/13	100
9	QC2	Inspect parts as they come off the CNC machine	Er	05/01/12	100
10	MV	Deburr and Tumble	Er	05/01/12	100
11	QC8	Second check	Er	05/01/13	100
12	FP	Acid etch and Alodine as per QSI 005 4.1	ml	05/01/13	100
13	QC5	Inspect work to Step 12	ml	05-01-19	100
14	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	ml	05-01-21	100
15	QC3	Inspect Powder Coat	ml	05-01-28	100
16	GA	Rivet spacers with support as per Dwg D3278. (Note: D3278-1/-2 are on BOM as material from Steps 2-3) Pick: Packing Kit Qty Part Number Description Batch 1 D3278-1 Support B21953A 1 D3278-2 Support B21953A 1 D3278-3 Spacer B21203 4 MS20426AD3-6 Rivet M1563	U	05-01-28	5
17	QC5	Inspect work to Step 16	ml	05-01-27	5

RELEASED

04-04-22

DART AEROSPACE LTD		Work Order:	21953
Description: Support Assembly		Part Number:	D3278-041
Dwg: D3278 Rev. A		Qty:	100 (5)
		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty																				
18	GA	Assemble support as per Dwg D3278 Pick: Packing Kit <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D2230-1</td><td>Clamp</td><td>- 021999</td></tr><tr><td>2</td><td>AN4-13A</td><td>Bolt</td><td>M15928</td></tr><tr><td>4</td><td>AN960JD416</td><td>Washer</td><td>M15993</td></tr><tr><td>2</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15020</td></tr></tbody></table> Identify as D3278-041	Qty	Part Number	Description	Batch	2	D2230-1	Clamp	- 021999	2	AN4-13A	Bolt	M15928	4	AN960JD416	Washer	M15993	2	MS21042L4	Nut (or -4)	M15020	ml	05-01-28	5
Qty	Part Number	Description	Batch																						
2	D2230-1	Clamp	- 021999																						
2	AN4-13A	Bolt	M15928																						
4	AN960JD416	Washer	M15993																						
2	MS21042L4	Nut (or -4)	M15020																						
19	QC5	Inspect work to Step 18	U	05-01-28	5																				
20	ST	Identify and Stock	CL	05/01/28	5																				
21	AC	Cost / part 32.21	S4C	05-01-31	5																				
22	DC	Close W/O 28.86 Inspect Level 21	WJ	05.01.28	5																				

Rev	Date	Change	Revised By	Approved
A	04.04.19	New issue	KJ/JLM	04/04/22

RELEASED
04/04/22

DART AEROSPACE LTD		Work Order:	21953
Description: Support		Part Number:	D3278-1
Inspection Dwg: D3278	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.098	✓			
0.365	+/-0.010	0.366	✓			
0.615	+/-0.010	0.621	✓			
0.250	+/-0.010	0.254	✓			
1.480	+/-0.010	1.480	✓			
R0.125	+/-0.010	0.125	✓			
0.125	+/-0.010	0.127	✓			
2.439	+/-0.010	2.436	✓			
1.980	+/-0.010	1.983	✓			
R0.130	+/-0.010	0.130	✓			
Ø0.257	+0.005/-0.000	0.257	✓			
R0.375	+/-0.010	0.375	✓			
0.875	+/-0.010	0.874	✓			
0.500	+/-0.010	0.499				
R0.400	+/-0.010	0.400				
1.720	+/-0.010	1.720	✓			
R0.125	+/-0.010	0.125	✓			
0.125	+/-0.010	0.130	✓			

Measured by: <i>EP</i>	Audited by: <i>me</i>	Prototype Approval:	N/A
Date: 05/01/12	Date: 05/01/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED

[Signature] 05-06-12

DART AEROSPACE LTD		Work Order:	21953
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.098	✓			
0.365	+/-0.010	0.370	✓			
0.615	+/-0.010	0.620	✓			
0.250	+/-0.010	0.250	✓			
1.480	+/-0.010	1.479	✓			
R0.125	+/-0.010	0.125	✓			
0.125	+/-0.010	0.127	✓			
2.439	+/-0.010	2.438	✓			
1.980	+/-0.010	1.986	✓			
R0.130	+/-0.010	0.130	✓			
Ø0.257	+0.005/-0.000	0.257	✓			
R0.375	+/-0.010	0.375	✓			
0.875	+/-0.010	0.874	✓			
0.500	+/-0.010	0.498	✓			
R0.400	+/-0.010	0.400	✓			
1.720	+/-0.010	1.720	✓			
R0.125	+/-0.010	0.125	✓			
0.125	+/-0.010	0.130	✓			

Measured by: <i>EP</i>	Audited by: <i>mf</i>	Prototype Approval:	N/A
Date: 05/01/11	Date: 05/01/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	<i>[Signature]</i>

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[Signature] 05/01/12

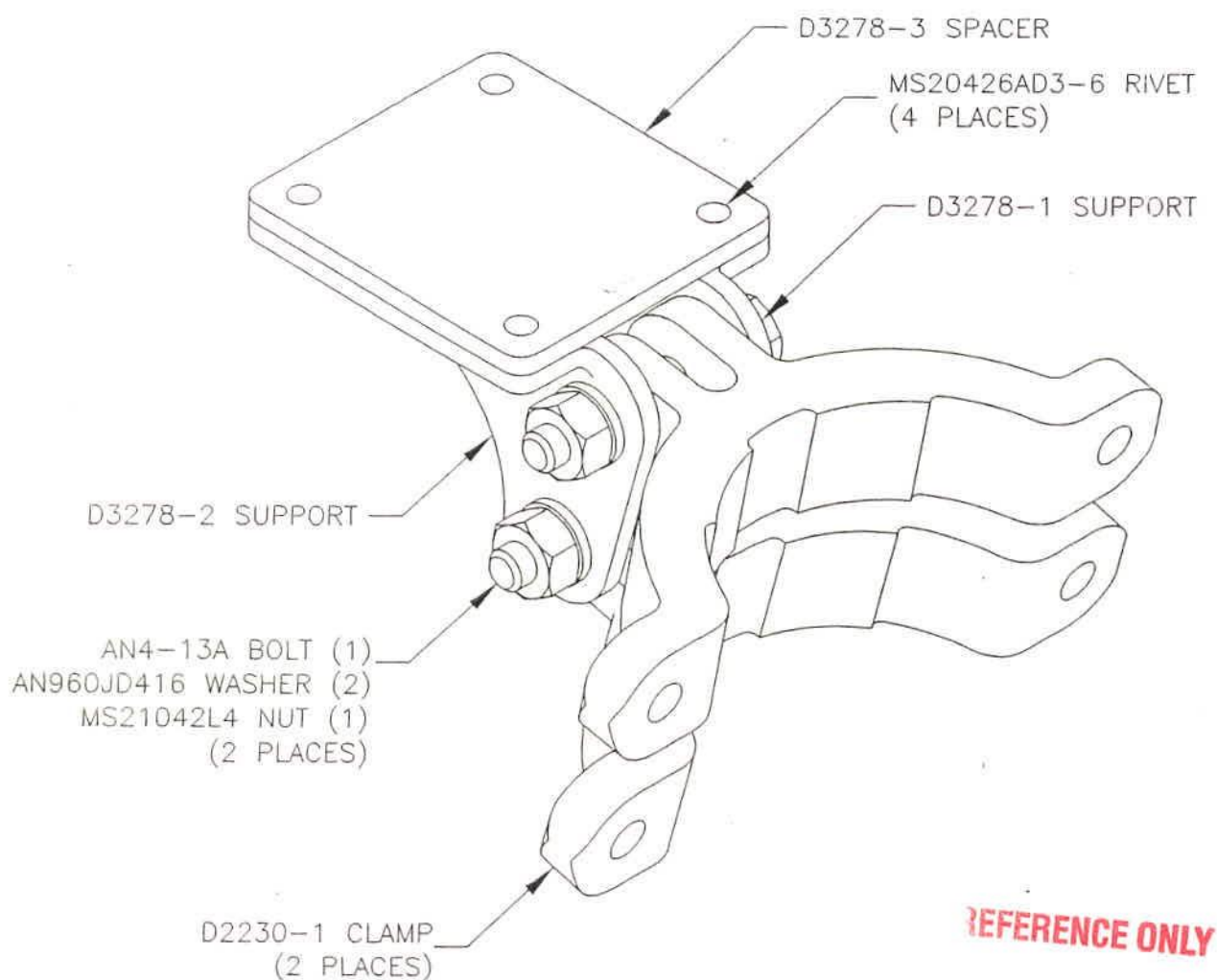


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01.04.05

DESIGN LP	DRAWN BY LP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3278	REV. A SHEET 1 OF 3
DATE 04.03.03		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	

D3278-041 SUPPORT ASSEMBLY



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